

Date: Friday, 11/18/2005 5:31:36 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 24878		
Estimate Number	: 10299		
P.O. Number	: N/A	Part Number	: D25775
This Issue	: 11/18/2005	Drawing Number	: D2577 REV E
Prsh Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: E
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT Below	Due Date	: 12/15/2005
Checked & Approved By	: SEE ABOVE USE DATE	Qty:	50
Comment	: Est: F 02.09.24 Re-format KJ/RF	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
	Comment: PURCHASING Issue P/O: <u>146</u> Email or Ship DXF file to vendor Laser Cut per Dwg D2577 flat pattern D2577-5 Material release note required	<u>U</u> 05/11/22
2.0	D25775F	Wearplate, Centre
	Comment: Qty.: 1.0000 U(s) Unit Total: 50.0000 U(s) WEAR PLATE FWD	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material release note is attached	<u>DL</u> 05/12/30 50
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK Inspect dimensions per template D2577-5T1	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	

W/O: 3000**WORK ORDER CHANGES**

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/22

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 5:31:36 PM
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Drawing Name: WEARPLATE

Job Number: 24878

Part Number: D25775

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

(50)

2-Form joggle using DT8157 as per Dwg D2577

3-Identify as D2577-5

SB 06/01/19

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J 06-01-20

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

(50)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 06 03 22

(50)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: f-1

M 08 03 22 (50)

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

L 06/03/22 (50)

Job Completion



W 06.03.22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 18, 2005
09:21 am

Work Order No : 0024878
Project Name : D2577-5 Department Code:
Project For : WK550 Burden Flags : NNNNNNNN
Work Order Type : Main WO Status : Open
Main WO Number : Invoice State : Not Invoiced
House Part Number : D2577-5 Invoice Date :
Description : Wearplate, Centre Invoice Number :
Manufactured : Yes Invoice Amount : 0.00
Amount Req'd : 50
Amount Done : 0 Order Entry No :
Start Date : 11-18-05 OE Value : 0.00
Est Finish Date : 12-15-05
Act Finish Date : Est Margin : 0.000%
Drawings Reqd : No Actual Margin : 0.000%
Ok for Approval :
Approval Rec'd : \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00	0.00	0.00
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00	0.00	0.00
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00	0.00	0.00
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00	0.00	0.00
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00	0.00	0.00
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00	0.00	0.00
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00	0.00	0.00
Total Cost	0.00	0.00	0.00	0.00	0.00
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
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(09) 235 8089 / 235 3553 Waiuku
Fax: (09) 375 8859

TEST CERTIFICATE

Ref: S210/22495

CUSTOMER	Wilkinson												SPECIFICATION ASTM A198 CS Type A						CERTIFICATE No TC112397							
CUSTOMER O/N	98-2JN-686												PRODUCT CBA WIDE COIL						PAGE 1 of 1							
MILL O/N	480737												DIMENSIONS 0.055" x 48" x Coil						DATE 09 June 2005							
PACK NUMBER	HEAT NO	CHEMICAL COMPOSITION PERCENT												MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)												
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nd	Ti	Al	B	N2	CE()	x1000	x100	BEND 180°	YIELD	T.S.	%ELONG G.L.=	HARDNESS HRB ()	LENGTH (feet)	
		x100		x1000																						
R9-459713-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1									54	1585			
R9-459714-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1									54	1457			
R9-459715-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1									48	1375			
R9-459716-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1									48	1473			
R9-459717-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1									48	1631			
R9-459718-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1									48	1093			
R9-459719-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1									50	1562			
R9-459720-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1									50	1535			
R9-460380-00	641761	4	TR	20	13	17	12	18	25	5	8	1	1									50	1581			
R9-460381-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1									49	1562			
R9-460382-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1									49	1503			
R9-461458-00	642309	2	TR	18	10	20	11	17	19	1	6	1	1									48	1785			

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (B)=50mm	PLASTIC STRAIN RATIO (r) (A)=r0 (B)=r90	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Amish Misra*
QC METALLURGIST

.065

16 ga ms
POT 146, 267, 245,

01/16/05 TUE 15:50 FAX 604 272 0061

INTEGRIS METALS

MTR MINNEAPOLIS

NO. 100

SIZE

INCH

INTEGRIS METALS LTD.

DESCRIPTION:

ASME

B31.3

SILVER

TUBE

STAINLESS STEEL

SHIRT ASI 304L

WELD

ASME

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STAINLESS STEEL

SHIRT ASI 304L

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New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 02121, Auckland, New Zealand
Telephones: (09) 375 8899 / 375 8111 Auckland
(09) 235 8899 / 235 3535 Waikato
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TEST CERTIFICATE

Ref: 5379/23650

Reissued 22/8/2005

CUSTOMER	Wilkinson	P5C5C5-DT002													SPECIFICATION		ASTMA1008 CS Type A						CERTIFICATE No		TC116858	
CUSTOMER QIN	98-21N-742														PRODUCT		CRA WIDE COIL						PAGE		1 of 1	
MILL QIN	486968														DIMENSIONS		0.033" x 48" x Coil						DATE		19 August 2005	
CHEMICAL COMPOSITION PERCENT																							MECHANICAL TESTS (TEST SPECIFICATION- ASTMA370)			
PACK NUMBER	HEAT No	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH		
		x100								x1000			x10000	x100	180°	G.L.=	HRB	()					()	(feet)		
R9-466080-00	845423	6	TR	21	11	16	17	20	16	2	3	1	3				Good				50		2700			
R9-466081-00	845423	6	TR	21	11	16	17	20	16	2	3	1	3				Good				50		2700			
R9-466082-00	845253	6	1	21	10	12	28	30	15	2	3	1	3				Good				47		2651			
R9-466083-00	845253	6	1	21	10	12	28	30	15	2	3	1	3				Good				47		2651			

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (B)=50mm	PLASTIC STRAIN RATIO (r) (A)=0 (B)=90	IMPACT TEST (C)=5mm x 6mm (A)=10mm x 10mm (B)=7.5mm x 10mm	(D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/8+(Cr+V+Mo)/5+(Cu+Ni)/15	(C)=C+Mn/6+Si/24 (D)=
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WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Santosh Misra*
OC METALLURGIST

20gans pof 267, 146,

